109168

Page 1

November-12-13 3:20:11 PM Item ID: D2939-1 Accept *N900040100* Setup Start Revision ID: Stop Item Name: 206 Saddle Left Side *10* Start Date: 11/12/13 **Start Otv:** 10.00 **Cust Item ID:** Required Date: 11/26/13 Req'd Qty: 10.00 *10* **Customer:** Reference: Run Process Plan: __MLJ __ Date: _\\ _\ Tooling: Approvals: Date: Stop QC:____ Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code **Qty** Qty Number Stamp **Draw Nbr Revision Nbr** Rev C D2939 100 0.00 HAAS CNC VERTICAL MACHINING #1 *100* 0.00 HAAS 1 Memo HAAS CNC vertical machine #1 Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per 0.00 110 CONVENTIONAL MILLING MACHINE _10__8 *110* 0.00 Mill Conv Memo Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet QC1- Inspect dimensions to dimension sheet 0.00 10 🔏 *120* 0.00 Memo Quality Control

DQA:			Date:											DART
						WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE			–	_	AEROSPACE
QA Closed:			Date:					-		W	ork Order up	date only		
Work Orde	r.			• 1.		DISPOSITION	İ		AGAINST	DE	PARTMENT	PROCESS		
Work Orac	٠					Rework			Skid-tube Crosstube]	Water Jet	٦ Er	ngineering
Part N	lo.					Scrap		,	Machining Small Fab		Pro	d. Eng. Coor.	1	Quality
	•					Use-as-is		Thern	noforming Finishing		Rec/Stor	e/Packaging]	Other
NCR N	lo.			<u>.</u>		Suspected Unapproved			Large Fab Composite			Supplier		
Root					Desci	ription of work order update	Ī	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
Design														
Doc/Data														
Equip/Tooling	_					X								
Handling/Pre	_					· •		Kr ² ,						
Material		**			ļ							-		
Operator	_													
Offset/Setup			-		<u> </u>				<u> </u>					
Process	_			3			ļ							
Supplier			`				İ							
Training				ļ			ļ							
Transport														
Unapproved				<u> </u>			<u> </u>							
							FAI	ULT CA	TEGORY		·-··			
Landii		1	•	`	_	General		11:-7	.	_]		٦,,,,	ssure/Forced
		Bending			-	Bend BOM/Route	\vdash	1 .	Program	┝	Outside Dim		_	-up
		Centre No	ot Concer	ntric	-	BOM/Route	\vdash	Grain		H	Over/Under Part Incorred		_	-up nperature/Cure
		Cracks	als/Dimmla	. /\&/=\	_	Broken/Damage/Defect	-	Hardwa		-	Part Lost/Mi	⊢	We	•
		Crimp/Kir	пк/кірріе	ywave	-	Burrs	\vdash	•	tion Incomplete/Unqualified		┥	-	1	ong Stock Pulled
		Cuffs			-	Contamination Countersink	3 :	4	tions Incomplete/Unclear gned/off center	\vdash	Part Moved Positioned V	L Vrong		ong stock runeu
	_	Crushing Heat Trea	at .			Cut Too Short	\vdash	Mislab		-	Power Loss/	_	Oth	ner
		Inspectio		Tube	-	Drawing		Misrea		<u> </u>	Ti owei coss/	L L	100	101
		Marks/Ch	•	lube	-	Drill Holes	\vdash	Off-set						
	\vdash	Turning S			-	Finish	\vdash	-1	Calibration					
	\vdash	Wave/Tw			一	Fit/Function		4	Sequence			****		·
	ı			-		1			·					

Work Order ID 109168

109168

Page 2

November-12-13 3:20:11 PM

Item ID:

D2939-1

11/12/13

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name:

Required Date: 11/26/13

206 Saddle Left Side

Start Oty: 10.00

Req'd Oty: 10.00

10 *10*

Date: SPC (Y/N):

Cust Item ID:

Customer:

Reference:

Approvals:

Date: Tooling:

Date:

Date:

Run

Stop

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130	Memo	0.00				_/\sqrt{\sq}}}}}}}}}}}}}} \sqite\seption}\sqrt{\sqrt{\sqrt{\sqrt{\sqrt{\sq}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}			SL13-12-4

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140 HandFinish

Hand Finishing

Memo

0.00

D 76134.4

150

150

Powdercoat Powder Coating White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

pb 13-12-6

DQA:			Date:										TRACT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP				AEROSPACE
QA Closed:			Date:							<u>W</u>	ork Order up	odate only	1
Work Orde	or.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
	- ' ' .					Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•				_	Use-as-is			moforming	Finishing		re/Packaging	Other
NCR N	١o.					Suspected Unapproved			Large Fab	Composite		Supplier] []
			,									· 	
Root		_	_	_	Desci	ription of work order update	l.	nitial	Actio		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
Design				;									
Doc/Data													
Equip/Tooling													
Handling/Pre Material													
Operator													
Offset/Setup													
Process													
Supplier							İ						
Training													
Transport													
Unapproved													
,							FA	ULT CA	TEGORY				
Landi	ng (Gear			_	General		,		_	_		_
!		Bending			<u> </u>	Bend	_	1	Program		Outside Dim	_	Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		_	Over/Under	—	Set-up
		Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		<u> </u>	Part Incorre	⊢	Temperature/Cure
	L	Crimp/Kir	nk/Ripple	/Wave	- }-	Burrs	<u> </u>	1 '	ion Incomplete/Und	· –	Part Lost/Mi	issing	Weld
	_	Cuffs			_	Contamination	_	4	tions Incomplete/Ur	nclear	Part Moved	L	Wrong Stock Pulled
į	L	Crushing				Countersink	L	•	gned/off center	-	Positioned V		Journal
	_	Heat Trea		T., L -	<u> </u>	Cut Too Short	-	Mislab		L	Power Loss/	Surge	Other
]	\vdash	Inspectio	•	ıube	-	Drawing	-	Misrea					
	<u> </u>	Marks/Ch			-	Drill Holes	\vdash	Off-set					
	-	Turning S			<u> </u>	Finish	\vdash	4	Calibration				
1	1	Wave/Tw	vist in Tub	e _		Fit/Function		Out of	Sequence				

Work	Order	ID .	10916	R
****	171 UCI	,	,	

400400

Dage 3

November-12-1.	3 3:20:11 PN	1			"109	1hx"						Page 3	
Item ID: Revision ID:	D2939-1			A	Accept	*N900	040	100)* s	Setup Start	ı V.	S1*	-
Item Name:	206 Saddle Le	eft Side								Stop	*N:	32 *	
Start Date: Required Date: Reference:	11/12/13 : 11/26/13	Start Qty: 10.00 Req'd Qty: 10.00		10* 10*		Cust Item I Customer:	D:						
Approvals:	Process Pla	an:	Date:		Tooling:	Da	ate:	_	R	tun Start	"IN F	₹1*	
			Date:		SPC (Y/N):	D:	ate:			Stop	*NF	₹2*	
Sequence ID/ Work Center I 160 *160* QC Quality Control 170 *170* Packaging Packaging	D	Operation Description QC3- Inspect Part Finish Memo Identify as per dwg & Stoo	ck Location: <u>C</u>	5T438	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty		Number	Insp. Stamp	
180 *1 R N * QC Quality Control		QC21- Final Inspection - V	Work Order R	clease	0.00				A /	Rm all	13/12/ 13/12/	10 ———	

DQA:			Date:												TOART
						WORK ORDER NON	-CC	NFO	RMANCE / UI				_		AEROSPACE
QA Closed:			Date:								Wo	ork Order up	date only		
Work Orde	ır.					DISPOSITION				AGAINST	DEF	PARTMENT	PROCESS		
Work Orde	٠.				-	Rework	1 		Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap		1	Machining	Small Fab	┪	Pro	d. Eng. Coor.	一	Quality
	•	. ,				Use-as-is	1		noforming	Finishing			e/Packaging	一	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier		
	•				-				_						
Root					Desc	ription of work order update	ı	nitial	Act			Sign &		ļ	,
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	<u> </u>	QC Inspector
Design														}	
Doc/Data	_]	
Equip/Tooling														ļ	
Handling/Pre														1	
Material															
Operator				:											
Offset/Setup														-	
Process															
Supplier									1						
Training			•												
Transport			1				l							1	
Unapproved			<u>]</u>	<u> </u>	<u> </u>		FΔI	UIT CA	TEGORY			J _.			
Landi	nø (Gear				General		-							
	.8	Bending				Bend		 Folio/F	Program			Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	J		Г	Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorre	ci		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified		Part Lost/Mi	ssing		Weld
		Cuffs				Contamination	Г	Instruct	tions Incomplete/L	Jnclear		Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center	:		Positioned V	Vrong		•
		Heat Trea	at			Cut Too Short		Mislabe	eled			Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d						
		Marks/Cl	natter			Drill Holes		Off-set				4			
		Turning S	Sequence	!		Finish		Out of	Calibration						
1		Waye/Tu	vict in Tuk	he		Fit/Function		Out of	Seguence						

Picklist Print

November-12-13 3:20:15 PM

109168

Work Order ID: 109168 D2939-1 Parent Item:

D2939-1

Parent Item Name: 206 Saddle Left Side

Start Date: 11/12/13

Required Date: 11/26/13

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: B00.06.26New DWG rev (mpp 2069)EC

IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	44.0000	1	10			
D6101-00	ገ1								**	2	13.	1(-2	راي

Saddle Billet

Location Loc Oty Loc Code MAT042 108097 108272 97239 2

DQA:			Date:										TRAGE
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE		O d · · · ·		AEROSPACE
QA Closed:			Date:			•				W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAINST	T DE	PARTMENT	/PROCESS	
Work Orac					_	Rework			Skid-tube Crosstube]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fat	_	Pro	d. Eng. Coor.	Quality
	-					Use-as-is			noforming Finishing	3 -	Rec/Sto	re/Packaging	Other
NCR N	١o٠					Suspected Unapproved			Large Fab Composite	-		Supplier	
Root	ī				Desc	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	i	ief Eng			Date	Verification	QC Inspector
Design												-	
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator											ļ		
Offset/Setup				1							:		
Process		İ											
Supplier													
Training													
Transport													
Unapproved]	<u></u>									
							FA	ULT CA	TEGORY				
Landi	ng (Sear				General	_	7			7	_	- 1
		Bending				Bend		1	Program		Outside Dim	<u> </u>	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		<u> </u>	Over/Under	-	Set-up
		Cracks				Broken/Damage/Defect	<u> </u>	Hardwa		_	Part Incorre	 	Temperature/Cure
	$\overline{}$	Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs		- 1 1	ion Incomplete/Unqualified	<u> </u>	Part Lost/M		Weld
	-	Cuffs				Contamination	<u> </u>	4	tions Incomplete/Unclear	\vdash	Part Moved	ļ	Wrong Stock Pulled
	<u> </u>	Crushing				Countersink		4	gned/off center	\vdash	Positioned V		٦
	<u> </u>	Heat Trea				Cut Too Short	<u></u>	Mislab		L	Power Loss/	Surge	Other
	\vdash	Inspectio	•	Tube	<u> </u>	Drawing		Misrea					
ļ	<u> </u>	Marks/Ch			\vdash	Drill Holes	<u> </u>	Off-set					
	<u> </u>	Turning S			<u> </u>	Finish		-	Calibration				
]	1	Wave/Tw	ist in Tul	be		Fit/Function	1	Out of	Sequence				

DART AEROSPACE LTD	Work Order:	109/68
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

		· · · · · · · · · · · · · · · · · · ·		Re	corded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		.119	6/1/	c [1]	-111		
В	0.100	0.140		.115	.110	.110	1113		
С	0.100	0.140		-112-	:112	.112	0110		72-72-10
D	0.210	0.230		1225	6224	ء 223	0226		
E	1.245	1.255		1.250	(250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505	· .	2.400	2.500	2.500	2.500		
Н	0.510	0.515		ららり	.514	.514	,514		
1	1.572	1.582		1.577	1.577	10576	1,578		
J	2.495	2.505		2.500	2.500	2.496	2.500		
K	0.257	0.262		.260	.260	.240	.260		
L	0.312	0.317		-316	.716	.316	.316		
М	0.235	0.240		.237	,237	.236	236		-
Ν	0.100	0.140		~(O3	119	~ i18.	1210		
0	0.540	0.560		.545	548	0547	,548 ,498		
₽	0.490	0.510		.496	.448	0497	.498		
Q	3.715	3.725		3.720	3.720	3.770	\$770		
R	2.720	2.760		2.743	2.740	2.740	2740		
S	0.240	0.270		-258	, 258	6258	v 258		
Т	0.100	0.180		.140	,140	140	,140		
U	1.625	1.635		1.630	1.630	1.630	1.428		
V	1.362	1.372		1.367	1.367	1368	10367		
W	0.316	0.321		3(6	.3[4	.3/te	:316		
Χ	1.250	1.270		1.258	1.260	1.2554	1.2579		
Y	1.565	1.585	DT8695 A/B	1.573	1.578	1.5698	1-5723		
Z	0.178	0.198		1.186	. 188	.188	.188		
AΆ									
AB									
AC									
AD		٠.							
ΑE									
AF									
AG									
AH									
	Acc	ept/Reje	ct						

_				
Measured by:	SA	Audited by	SL	
Date:	13-11-30	Date:	13-12-4	

Date	Change	Revised by	Approved
	New Issue	RF	
02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	2/1
07.03.21	Revised per drawing revision C	KJ/JLM c	411
The state of the s	02.12.12	New Issue 02.12.12 Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	New Issue RF 02.12.12 Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B KJ/RF

Date:										
WORK ORDER NON-CONFORMANCE / UPDATE	AEROSPACE									
QA Closed: Date: Work Order updat	te only									
Work Order: DISPOSITION AGAINST DEPARTMENT/PR	'ARTMENT/PROCESS									
	Water Jet Engineering									
	Eng. Coor. Quality									
Use-as-is Thermoforming Finishing Rec/Store/P										
NCR No. Suspected Unapproved Large Fab Composite	Supplier									
Root Description of work order update Initial Action Sign &										
Cause Date Step Qty or non-conformance Chief Eng Description Date V	Verification QC Inspector									
Design										
Doc/Data Doc/Data										
Equip/Tooling										
Handling/Pre Handling/Pre										
Material										
Operator										
Offset/Setup Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										
FAULT CATEGORY										
Landing Gear General	-i									
Bending Bend Folio/Program Outside Dimens Centre Not Concentric BOM/Route Grain Over/Under tole	—									
	Temperature/Cure									
	· · · · · ·									
	Wrong Stock Pulled									
Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surg										
Inspection Strip in Tube Drawing Misread	ge Journey									
Marks/Chatter Drill Holes Off-set										
Turning Sequence Finish Out of Calibration										
Wave/Twist in Tube Fit/Function Out of Sequence										

DART AEROSPACE LTD	Work Order:	109168
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Rě	corded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	54	6 %	7点	8 \$	Ву	Date
Α	0.100	0.140		6114	-111	olll	5110		
В	0.100	0.140		108	108	109	110		
O	0.100	0.140		112	113 س	6113	i113		
О	0.210	0.230		c 223	0222	,221	, 221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
Н	0.510	0.515		1514	,514	,514	,514		
1	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		7.497	2.500	2.498	2.498		
K	0.257	0.262		. 260	260	.260	.260		
L	0.312	0.317		, 3/4	:314	.3/4	.3/4		
М	0.235	0.240		,235	. 235	.236	o 235		
N	0.100	0.140		0//10	.116	6115	.115		-11
0	0.540	0.560		0548	.548	,5475	1548		•
Р	0:490	0.510		.4985		.499	,548 ,498		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.158	.259	.158	258		
Т	0.100	0.180		.140	140	140	.140		
C	1.625	1.635		1.630	1.630	1.630	1.430		
V	1.362	1.372		1.367	1.367	1.367	1.347		
W	0.316	0.321		.316	.316	.316	. 3/6		
Х	1.250	1.270		1.254	1.2546	1.2542	1.2543		-
Υ	1.565	1.585	DT8695 A/B	1.5692	1.5697	1.569	1.5692		
Z	0.178	0.198		.188	.188	.188	. 188		
AA					T				
AB									
AC									
AD									-
ΑE									
AF									
AG								"	
AH									
	Acc	ept/Reje	ct						

// //	
Measured by:	Audited by JL
Date: 13-11-30	Date: 13-12-4

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
С	07.03.21	Revised per drawing revision C	KJ/JLM 🚓	411

DQA:		Date:										
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPD	DATE			AEROSPACE
QA Closed:		Date:							W	ork Order up	date only	· .
Work Order					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	·
					Rework	l		Skid-tube	Crosstube]	Water Jet	Engineering
Part No				:	Scrap			Machining	Small Fab	Proc	l. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR No.				Suspected Unapproved]		Large Fab (Composite]	Supplier		
		<u> </u>	 			!	. '. ' . 1	A -4:		C: 0		<u> </u>
Root			Desci	ription of work order update	l	nitial	Action		Sign & Date	Verification	QC Inspector	
Cause	Dat	e Step	Qty		or non-conformance	Cn	ief Eng	Descript	шоп	Date	Verification	QC Inspector
Design Doc/Data	-											
Equip/Tooling	┪											
Handling/Pre	1				•							
Material	1											
Operator	1											
Offset/Setup												
Process												
Supplier												·
Training		į				1					•	
Transport	_											
Unapproved												
						FAI	ULT CA	TEGORY				
Landing	_			·	General		1	_		7		٦, ،
	Bend	-			Bend		1	Program	<u> </u>	Outside Dim	<u> </u>	Pressure/Forced
-	-1	e Not Conce	ntric	-	BOM/Route		Grain		<u> </u>	Over/Under		Set-up
-	Crack		. 644		Broken/Damage/Defect	_	Hardwa		ralified	Part Incorred	_	Temperature/Cure Weld
<u> </u>	_	/Kink/Ripple	e/wave		Burrs	\vdash	1 '	ion Incomplete/Unqu	<u> </u>	Part Lost/Mi Part Moved	- Sille	Wrong Stock Pulled
	Cruck	ina		-	Contamination Countersink	-	4	tions Incomplete/Und gned/off center	Lieai	Positioned V	/rong	TWI OIIS STOCK Fulled
<u> </u>	Crush	ing Treat		\vdash	Cut Too Short	\vdash	Mislabe		 	Power Loss/		Other
-	⊣	rreat ction Strip ir	Tube	-	Drawing	\vdash	Misrea			الـ (1.000)		10.00
-	⊣ `	s/Chatter	. 1450		Drill Holes		Off-set					
\ \	Turning Sequence Finish						Out of Calibration					
		/Twist in Tu			Fit/Function		4	Sequence				

DART AEROSPACE LTD	Work Order:	109/68
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

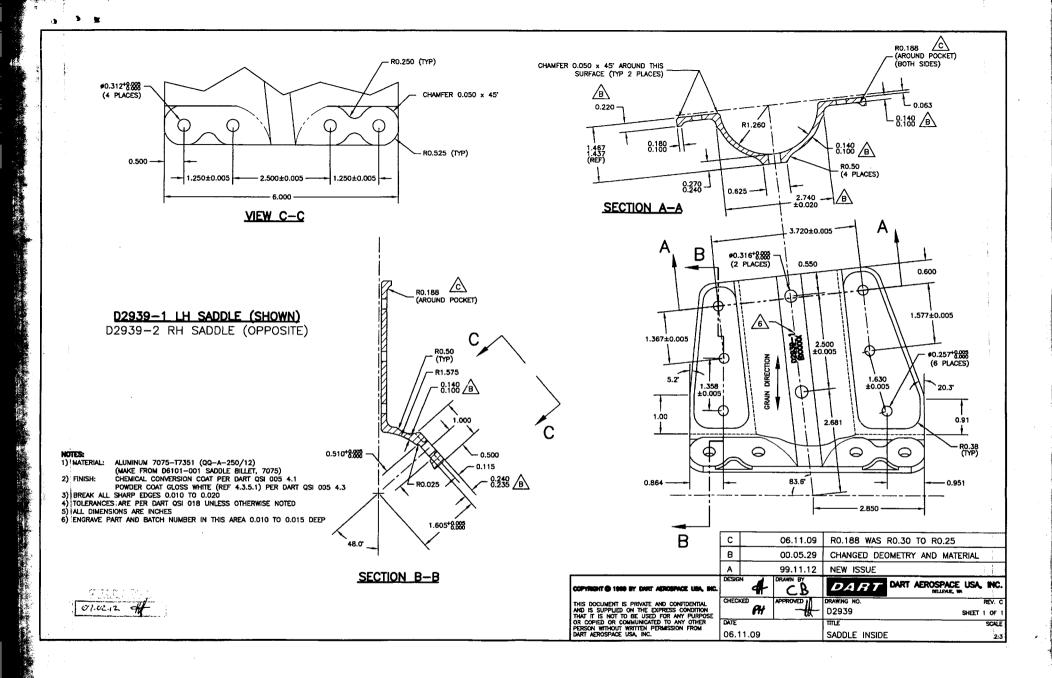
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Red	orded Act	ual Dimensio	ns		
Dim	Min	Max	Go/No Go Gauge	9 &	(O 2.	3.	4	Ву	Date
Α	0.100	0.140		6112	ا1ا5ء				
В	0.100	0.140		.110	.109				
С	0.100	0.140		e 112	0110				
D	0.210 _	0.230		0112 0221	0110 221				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250	-			
G	2.495	2.505		2.500	2.500 \$14 [,577		· · · · · · · · · · · · · · · · · · ·		
Н	0.510	0.515		,514	°514				
Ī	1.572	1.582		,514 1.577	1.577				
J	2.495	2.505		2.499	1.499				
K	0.257	0.262		.24.0	.260				
L	0.312	0.317		235 235	.260				
М	0.235	0.240		,235	.236				
N	0.100	0.140		1.115	0115				
0	0.540	0.560		.548 .498	.548				
Р	0.490	0.510		.498	.497				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.740	7.740				
S	0.240	0.270		ا 258ه ا	,255				
T	0.100	0.180		140	.140				
U	1.625	1.635		1.630	1.430				
V	1.362	1.372		1368	1.368				,
W	0.316	0.321		1.2527	.316				
Х	1.250	1.270		1.2527	1.2533				
Υ	1.565	1.585	DT8695 A/B	1.5679	1.5688				
Z	0.178	0.198		1.5679	. 188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
АН									
	Acc	ept/Reje	ct						

Measured by:	Audited by SL
Date: 13-11-31	Date: /3-/2-4

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
С	07.03.21	Revised per drawing revision C	KJ/JLM O	

DQA:			Date:										TRACT		
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP				AEROSPACE		
QA Closed:			Date:							W	ork Order up	date only			
Work Orde	er:					DISPOSITION				AGAINST DEPARTMENT/PROCESS					
	-					Rework	Skid-tube Crosstube			Crosstube	7	Water Jet	Engineering		
Part No.						Scrap		ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
				Use-as-is	1 1	Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other				
NCR No.				Suspected Unapproved			Large Fab	Composite		Supplier					
Root					Desci	ription of work order update	Ī	nitial	Acti	on	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector		
Design			<u>.</u>									•			
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material				i											
Operator															
Offset/Setup							ļ								
Process				,											
Supplier															
Training															
Transport															
Unapproved									<u> </u>						
							FAI	ULT CA	TEGORY						
Landi		ı				General		1 .		_	7	_	-		
		Bending				Bend		4	Program	!	Outside Dim	<u> </u>	Pressure/Forced		
		Centre No	ot Concer	ntric		BOM/Route	<u> </u>	Grain			Over/Under	<u> </u>	Set-up		
		Cracks			_	Broken/Damage/Defect	-	Hardwa		<u> </u>	Part Incorre		Temperature/Cure		
	_	Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs	$ldsymbol{ld}}}}}}$	Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	Weld		
		Cuffs			_	Contamination	L	4	tions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled		
	<u> </u>	Crushing			<u> </u>	Countersink		1 7	gned/off center	<u> </u>	Positioned V		¬		
Heat Treat					Cut Too Short		Mislabe		<u></u>	Power Loss/	Surge	Other			
	Inspection Strip in Tube					Drawing	<u></u>	Misrea							
ł	Marks/Chatter					Drill Holes	_	Off-set							
	<u> </u>	Turning S				Finish		-	Calibration						
1		Wave/Tw	ist in Tub	ре		Fit/Function		Out of	Sequence						



109/68 MC5

DQA:			Date:	te:												
						WORK O	RDER NON-	-CC	NFOI	RMANCE / UI	PDATE					AEROSPACE
QA Closed:			Date:									Wo	ork Order up	date only		
Mande Ond						DISPO	OSITION	,								
Work Orde	er:						Samuel College						Water Jet [\neg	Engineering	
Part N	lo.						Rework Scrap			Skid-tube Machining	Crosstube Small Fab	—			┨	Quality
	-						Use-as-is		,	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR No.			·	Suspected U	napproved			Large Fab	Composite			Supplier				
Doot	_		<u> </u>		Doss	rintian of work	ordor undata		nitial	l Act	ion_		Sign &		1	**************************************
Root		Date	Ston	O+1/	Desc	ription of work or non-confor			inual ief Eng		Action Description		Date	Verification		QC Inspector
Cause		Date	Step	Qty		or non-como	mance	Cii	iei ciig	Desci	iption		Date	vermeation	+	QC IIISPECTOI
Design Doc/Data	\dashv										•					
Equip/Tooling															İ	
Handling/Pre																
Material	一						İ							•	-	
Operator	\Box		İ												1	
Offset/Setup														-		
Process																
Supplier															ļ	
Training													,			
Transport		:								1						
Unapproved																
								FAI	ULT CA	TEGORY	···					
Landi	$\overline{}$	1			_	Gene	ral		1 .				1	r		
		Bending			<u> </u>	Bend			1 '	Program			Outside Dim	F	_	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		<u> </u>	Grain				Over/Under	F		Set-up
		Cracks			<u> </u>	Broken/Dama	ge/Defect	_	Hardwa				Part Incorre	F	-	Temperature/Cure
	<u> </u>	Crimp/Kir	nk/Ripple	/Wave	_	Burrs		<u> </u>	4 '	ion Incomplete/Ur	•		Part Lost/Mi	ssing	-	Weld
	\vdash	Cuffs			\vdash	Contamination		$\overline{}$	4	tions Incomplete/l	Jnclear	-	Part Moved			Wrong Stock Pulled
	\vdash	Crushing			<u> </u>	Countersink		\vdash	4	gned/off center		\vdash	Positioned V		\neg	0.1
	Heat Treat				<u> </u>	Cut Too Short		<u> </u>	Mislabe				Power Loss/	Surge _	1	Other
	Inspection Strip in Tube					Drawing	,		Misrea							-
	Marks/Chatter Turning Sequence					Drill Holes		\vdash	Off-set					<u> </u>		
	<u> </u>				<u> </u>	Finish		H	4	Calibration						
1	Wave/Twist in Tube					Fit/Function		1	JUUT OF	Sequence						